



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00432-3G-PO
Job Sheet 191287



Part No: RBW6205G00432-3G-PO **Job Qty:** 3 pcs

Part Name: Main Rotor Pitch Control Link Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No:

Due Date: 4/29/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00432-3G Rev.5 IPP Rev. A 19.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	3 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1	APR 01 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	3 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	APR 01 2019
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S168350



Part: RBW6205G00432-3G

Job No: 191287

Serial No/Batch: S168350

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 04/01/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 42	
					QC 6 - 9	
120	QC 6	3 pcs	4/29/19	0.00 0.00	QC 6 - 68	DAS APR 01 2019 68
					QC 6 - 61	9-89
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MLL
130	Small Fab - 2 - B4B	3 pcs	4/29/19	0.00 1.50	Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
140	QC 5	3 pcs	4/29/19	0.00 0.00	QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	APR 09 2019 DAS
					QC 5 - 50	40
					QC 5 - 30	9-89
150	Packaging 3-1 - Stock - B4B	3 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - FG	3 pcs	4/29/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

DAS

APR 11 2019 70

9-89

Part Op **100** - Issue PO to ARROW TECH MACHINE WORKS P/O: 042715 MANUFACTURE RBW6205G00432-3G AS PER
 Descriptions: DWG -Certificate of conformity is required
110 - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBW6205G00432-3G and install using #2 drive screws. .
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90081A077	Drive Screw #2 1/4" Long	12 Ea (4 ea)	130-Small Fab - 2 - B4B	5148008
RB41011	Dart Tooling Placard, Aluminum	3 Ea (1 ea)	130-Small Fab - 2 - B4B	5021040
RBW6205G00432-3GP 3ea. 100-Purchasing				5168195

Job Allocations

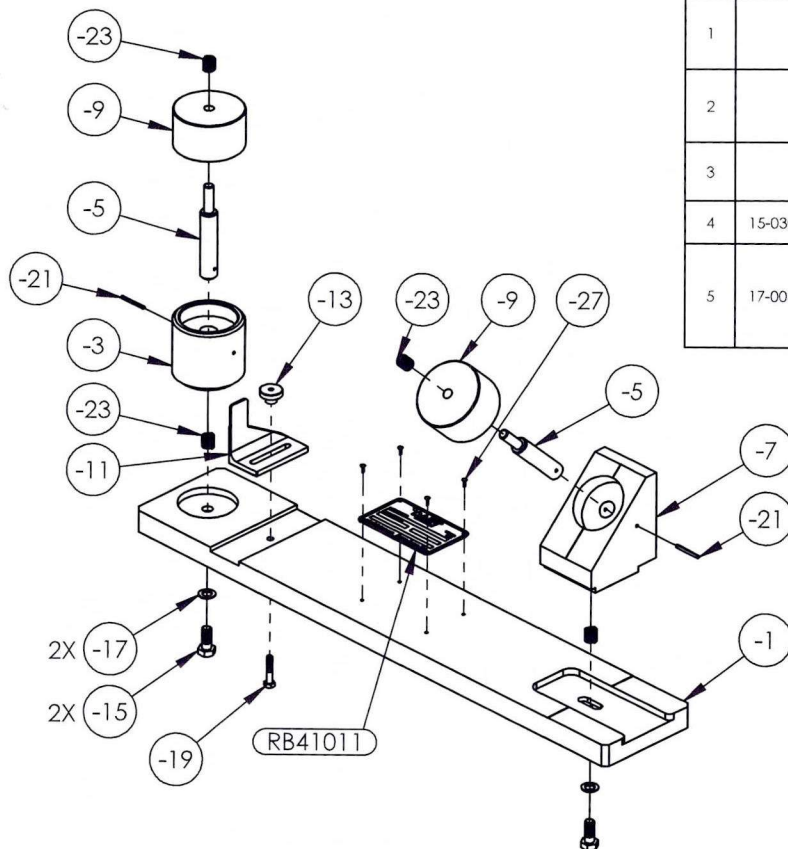
Operation	Component Part	Required	Inventory	Allocated
130-Small Fab - 2 - B4B	90081A077	12	106	0
	RB41011	3	401	0

Part Specifications

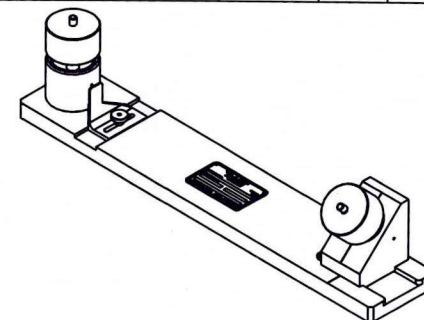
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 CH'D ENGRAVE NOTE.	5/28/2009	RJC	RW
1		-1 DELETED ENGRAVE NOTE. CH'D FINISH. -3 ADDED ENGRAVE NOTE AND UNDERCUT NOTE, CORRECTED DIM .18 X 45° TO .08 X 45°. -5 ADDED FINISH. -7 ADDED ENGRAVE NOTE, ADDED DIMS TO LOCATE Ø.098 HOLE. -9 ADDED ENGRAVE NOTE, CORRECTED HELI-COIL THREAD CALL OUT. -11 ADDED ENGRAVE NOTE, CH'D DIM WAS R.210 IS R.250.	5/3/2011	RJC	
2		-1 ADDED TOLERANCES TO SLOTS, ADDED COUNTERBORE. -3 CH'D COUNTERBORE DIA. FROM Ø.562, ADDED TOLERANCE TO Ø1.966, CH'D HOLE FOR -21 FROM Ø.098. -5 CH'D HOLE FOR -21 FROM Ø.094, ADDED TOLERANCE TO Ø.561 DIM. -7 CH'D COUNTERBORE FROM Ø.562, ADDED TOLERANCE TO 1.967 DIM.	5/16/2012	RJC	GE
3		-1 CH'D FINISH WAS POWDER COAT YELLOW IS ANODIZE RED, REMOVED MASKING NOTES AND ASSOC. DIMS. -7 ADDED LOCATION DIM FOR Ø.098 HOLE 1.745 FROM BOTTOM OF PART & REMOVED EXTRANEOUS CONSTRAINTS. -11 CH'D DIM WAS 1.250 IS 1.250 ±.030.	2/13/2013	BIM	SE
4	15-0308	-1 ADDED Ø.089 HOLES FOR PLACARD. -3, -7, -9 & -11 CH'D ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. -5 CH'D MATERIAL CALLOUT WAS G&P 4140 IS 4140 G&P / 4142 G&P.	9/16/2015	RJC	JAG
5	17-0065	UPDATED TO NEW STANDARDS. -1 ADDED DIM 2X R.2. -3 REMOVED DIM Ø.628 FOR -23 HELI-COIL; ADDED NOTE 'TAP FOR -23 HELI-COIL'. -5 CH'D MAT'L WAS 4140 G&P/4142 G&P IS 4140/4142; CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE 1 SC2. -7 CH'D DIM WAS .463 IS (.463). WAS .876 IS (.876). WAS Ø.323 Ø.63 FOR -23 HELI-COIL IS Ø.63 TAP FOR -23 HELI-COIL; ADDED DIM .614, 2.721, 1.791; REMOVED DIM .983. -9 REMOVED DIM Ø.328 FOR -23 HELI-COIL; ADDED NOTE 'TAP FOR -23 HELI-COIL'.	3/17/2017	SM	JAG



NOTE:

ORIGINAL REF. NO.

RBW6205G00432 ASSY. = 3G6205G00432

RBW6205G00432-1 = 3G6205G00852

RBW6205G00432-3 = 3G6205G10831

RBW6205G00432-7 = 3G6205G10931

RBW6205G00432-9 = 3G6205G11031

RBW6205G00432-11 = 3G6205G01551

DO NOT USE FOR REFERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061		2
			-3	1	ROUND SEAT	6061		3
			-5	2	STUD	4140/4142		4
			-7	1	SLIDE SEAT	6061		5
			-9	2	KNOB	6061		6
			-11	1	POINTER	6061		7
		B/O	-13	1	THUMB NUT	S.S.	#10-32 UNF (ESSENTA #SKN-55)	1
		B/O	-15	2	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF (SPENCER AIRCRAFT #AN5-5A)	1
		B/O	-17	2	FLAT WASHER	STEEL	Ø5/16 (SPENCER AIRCRAFT #AN960-516)	1
		B/O	-19	1	HEX HEAD CAP SCREW	STEEL	#10-32 UNF X 7/8 (SPENCER AIRCRAFT #AN3-7A)	1
		B/O	-21	2	ROLL PIN	STEEL	Ø3/32 X 1 (MCMMASTER-CARR #98296A861)	1
		B/O	-23	4	HELI-COIL	S.S.	5/16-24 UNF X 1/2 (MCMMASTER-CARR #91732A233)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1
		B/O	-27	4	#2 DRIVE SCREW	COATED STEEL	Ø.1 X 1/4 (MCMMASTER-CARR #90081A077)	1

		TITLE	
		M/R PITCH CONTROL LINK ADJUSTING TOOL	
DWG NO.		RBW6205G00432-3G	
REV		5	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		.X ± .1 SURFACES = 125/	
CHECKED:		1. BREAK ALL SHARP EDGES	
OPPS APPR:		.015 x 45° OR .015R	
QA APPR:		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE		3. INTERPRET DIM AND TOL PER	
1:4		ASME Y14.5M-2009	
DATE		USED ON MODEL	
1/19/2008		AGUSTA	
SHEET 1 OF 8			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042715



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042715
PO Date: 2/26/19
Due Date: 4/29/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick **Phone:**

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191266	RBW0805G00332-3Gp			Jacking Bracket, Helicopter Weighing REV 2	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$788.75/pcs	\$2,366.25
								3X MAR 26 2019					
2		RBW6005G01431-3Gp			Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	4/29/19	2 pcs	0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
								2X MAR 29 2019					
3	191286	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
4	191287	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
								3X APR 01 2019					
Grand Total:												\$13,981.50	



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PURCHASE ORDER PO042715



Order Notes

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Three handwritten signatures in black ink, stacked vertically on the right side of the order notes section.

Plex 2/26/19 11:48 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 490

Date: 3/28/2019
PO Ref: 042715 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
2	SUPPORT, DIAL INDICATOR MAIN ROTOR DAMPER ASSEMBLY	RBW6005G01431-3G
3 ✓	M/R PITCH CONTROL LINK ADJUSTING TOOL	RBW6205G00432-3G ✓

Received by: _____

Packaged by: _____

Checked by: _____

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042715 / Dated: 4/28/2019

Our Order / Job No: 042715-4AWT Order Qty: 3

Part Name: M/R PITCH CONTROL LINK ADJUSTING TOOL

Part Number RBW6205G00432-3G

Lot Size: N/A Ship Date: 4/28/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G00432-3G Rev: 5

Material Size and Type: -1, -3, -7, -9, -11/ 6061 ALUM.; -5/ 4140 STEEL

Material Specifications: ALUM.: ASTM B221; STEEL: ASTM A29

Heat Treatment: N/A

Plating/Finish: RED ANODIZE: MIL-A-8625, TYPE II, CLASS II; CLEAR ANODIZE: MIL-A-8625, TYPE II, CLASS I; ZINC PLATE: ASTM B6336 TYPE I, SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/28/19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com